

Work Order ID 58697

Monday, May 17, 2010 10:09:22 AM



Page 1

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 5/17/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-5-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4034

A

100

Weld per dwg A/R S.S. rod Batch: *1111679* 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

10.05.18

3

q

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

③ 10.05.18

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

S. Webster

④

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Page 2

Item ID: D4034-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Fwd Upper Rib Assembly
Start Date: 5/17/2010 Start Qty: 3.00  Cust Item ID:
Required Date: 5/21/2010 Req'd Qty: 3.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				<u>3</u>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

SAP 10-05-17

10/05/18 MF

10-5-18

W/O:			WORK ORDER CHANGES					
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Monday, May 17, 2010 10:09:22 AM

[illegible]

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4034-1 Rib		Manufactured	No			100	Each	6.0000	1		10.05.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA	358405	6						
					200003	6						
D4034-5 Rib		Manufactured	No			100	Each	3.0000	1		10.05.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		3						
					58407	3						
D2327-3 Spacer Bushing		Manufactured	No			100	Each	4.0000	1		10.05.17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		4						
					57790	4						
D4021-7 Hoop		Manufactured	No			100	Each	2.0000	1		10.05.17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA	358484	2						
					58039	1						
					58153	1						

W/O:			WORK ORDER CHANGES					
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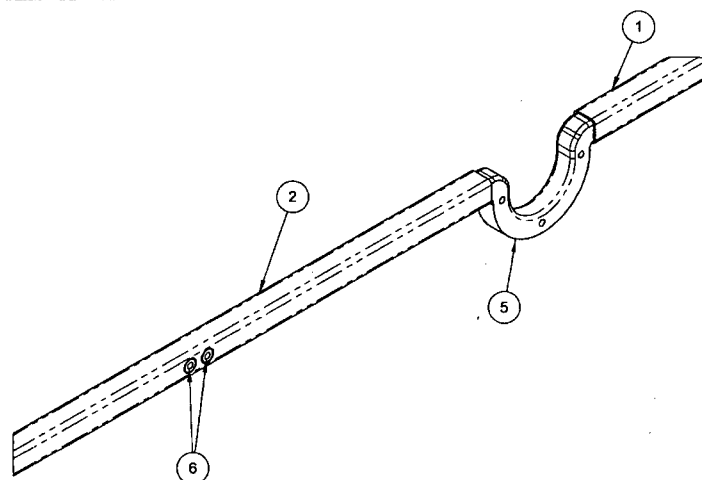
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

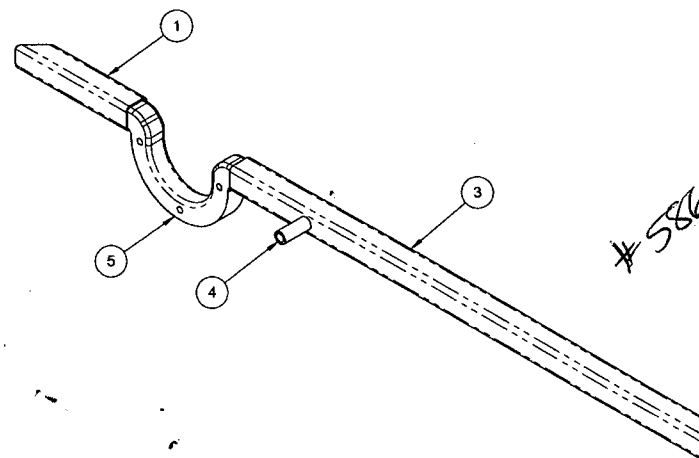
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
MP

A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	MP		
USE APPR.	MP		
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4034** REV. A
SHEET 1 OF 4
TITLE **UPPER RIB ASSY, BASKET BASE** SCALE **NTS**

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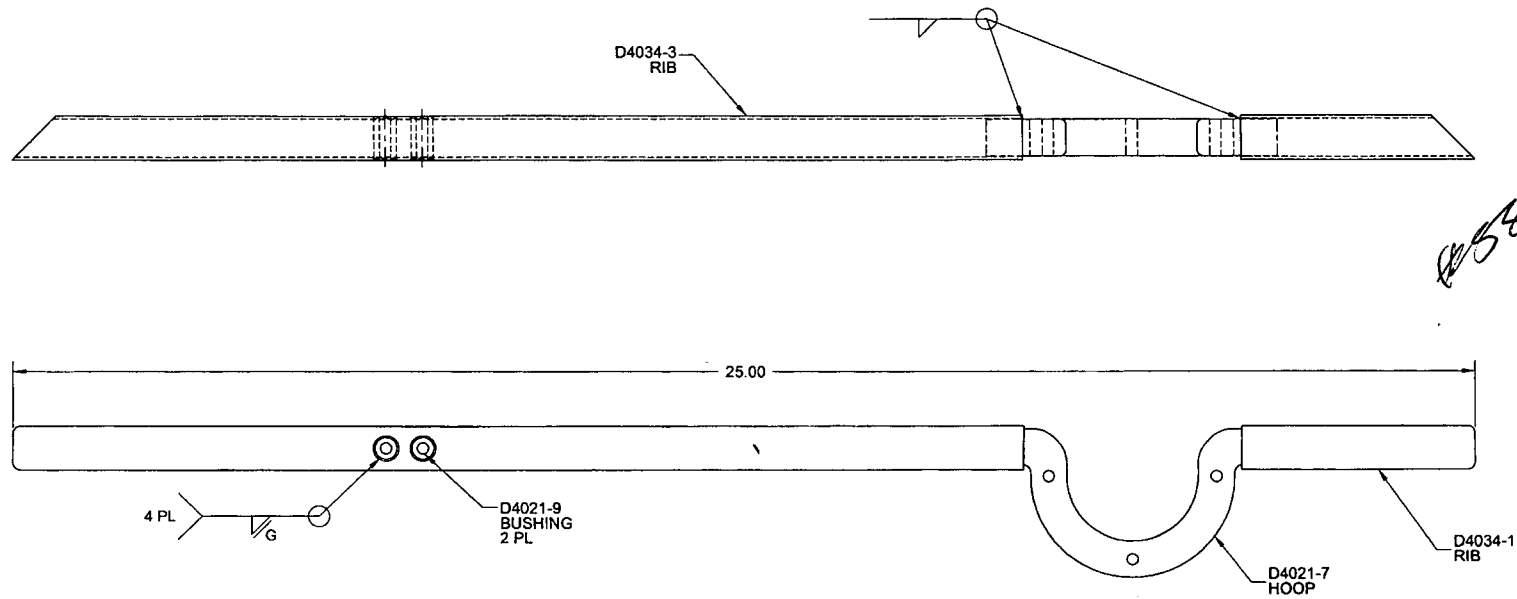
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4034-041 AFT UPPER RIB ASSY

RELEASED
2010-03-12
AM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.59 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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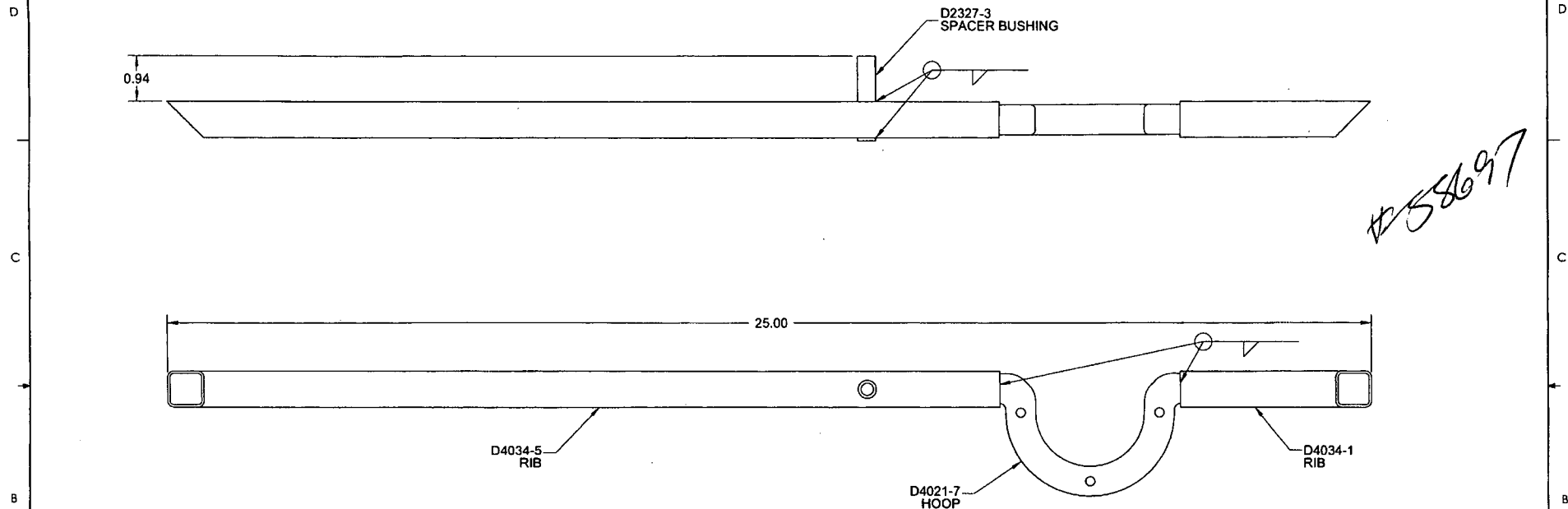
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#58697

D4034-043 FWD UPPER RIB ASSY

RELEASED
2010-03-12
MD

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.58 lbs
 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JE	D4034	SHEET 3 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	TH	UPPER RIB ASSY, BASKET BASE	NTS
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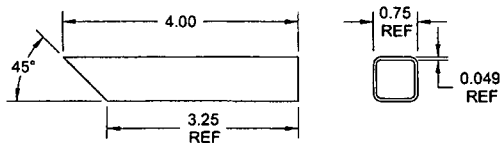
W/O:			WORK ORDER CHANGES					
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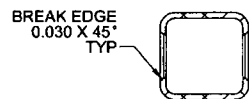
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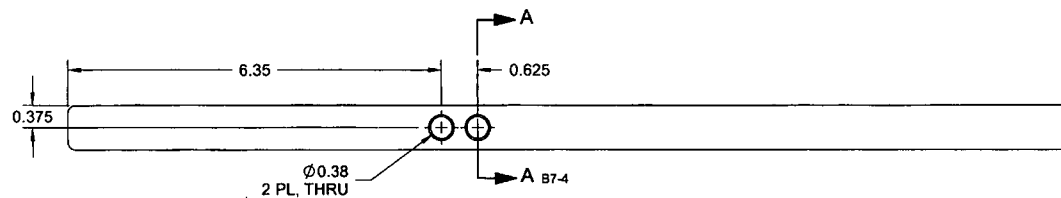
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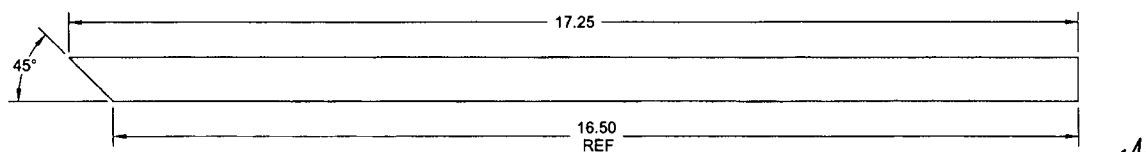
D4034-1 RIB



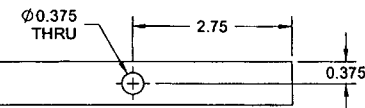
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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